



Dart Aerospace Ltd.
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D2654-7**Job Sheet 216229****Part No:** D2654-7**Job Qty:** 2 pcs**Part Name:** Web**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/3/20**Job Tracking No:****Due Date:** 1/4/21**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV F SHEET 2 IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM IPP Rev:e 06.04.05 Added level21 EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	2 pcs	1/2/21		0.00	1.42	Skidtubes - 1		TF Dec, 04, 2020
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	Handfinish - 1-1 Chemical-B4B	2 pcs	1/4/21		0.00	0.54	Handfinish - 1 - 1 - B4B		BFB 09/12/2020
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		
							Handfinish - 1 - 16 - B4B		
							Handfinish - 1 - 17 - B4B		
							Handfinish - 1 - 18 - B4B		
							Handfinish - 1 - 19 - B4B		
							Handfinish - 1 - 20 - B4B		
							Handfinish - 1 - 21 - B4B		
							Handfinish - 1 - 22 - B4B		
120	QC 5	2 pcs	1/4/21		0.00	0.00	QC 5 - 10		

**Container No:** S318228**Part:** D2654-7**Job No:** 216229**Serial No/Batch:** S318228**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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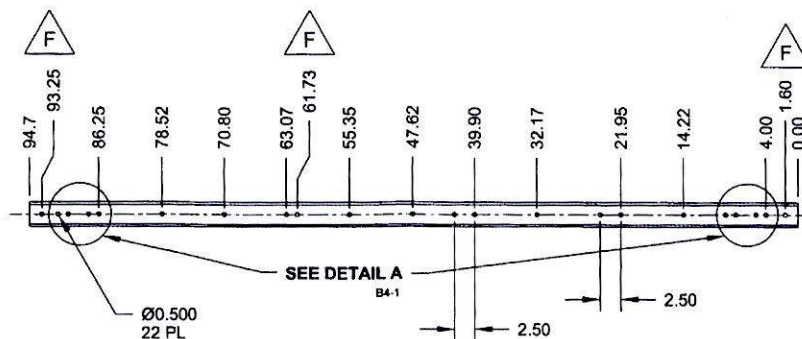
Date: 12/04/20

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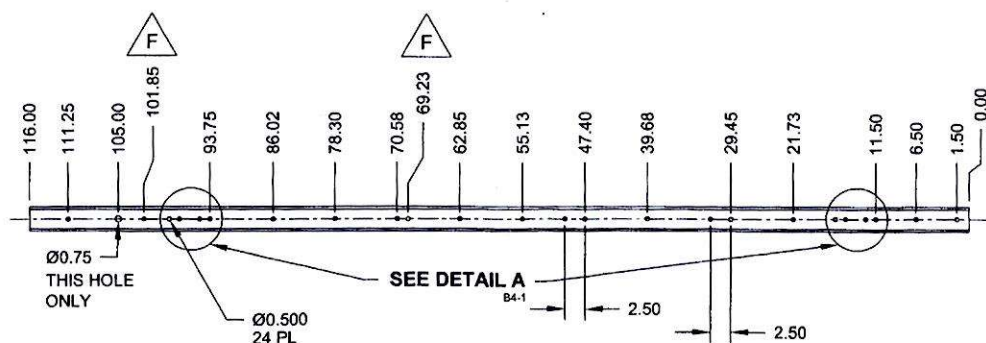
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
130	QC 7	2 pcs	1/4/21	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
					QC 7 - 61
					QC 7 - 81
					QC 7 - 76
					QC 7 - 79
					QC 7 - 83
					QC 7 - 82
					QC 7 - 87
140	Packaging 3-1 - Stock - B4B	2 pcs	1/4/21	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B

				Packaging 3 - 6 - B4B	DAS 03 20.12.9
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	2	1/4/21	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 9	DEC 09 2020
				QC 21 - SA - 77	
				QC 21 - SA - 28	
Part Op 100 - 1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654 3-Descriptions: Using the uni-bit, open holes to finish size as per Dwg D2654 110 - (Chemical Conversion Coat per QSI005 4.1) 120 - (QC5- Inspect part completeness to step on W/O) 130 - (QC7-Inspect Chemical Conversion Coat) 140 - (Identify as per dwg & Stock Location: <u>66002</u>) 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2600-7-140	Extrusion I-Beam Thick	2 pcs (1 ea)	100-Skidtubes - 1	B169463 S046288	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Skidtubes - 1	D2600-7-140	2	67	0	
Part Specifications					
Specifications could not be found.					

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D2654-5 WEB



D2654-7 WEB

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 216229 MW

2012-03

RELEASED
2011-09-12
MM

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2654	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			